

Date: Friday, 07/07/2006 8:59:14 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER KIT
Job Number	: 27584		
Estimate Number	: 11800		
P.O. Number	: NIA	Part Number	: D25253
This Issue	: 07/07/2006 S.O. No. : NIA	Drawing Number	: D2525 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 15/06/2006 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: NIA	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 30/06/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	20 Um: Each
Comment	: Est. B99.11.10 Re-format added Acid etch stepEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0750	6061-T6 Round Bar .750"
	Comment: Qty.: 0.0220 f(s)/Unit Total : 0.4400 f(s) 6061-T6 Round Bar .750"	
		M100157 06/07/11
2.0	LATHE CONV.	CONVENTIONAL LATHE
	Comment: CONVENTIONAL LATHE	
		06/07/11 20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		06/07/11 20
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
		SA 06.07.11 20
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	
		SAD 06.07.12 20
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
		06.07.13 20 P10

Date	Step	
06-07-13	6	QC 3 for Alkaline. Perm. Change. <i>[Signature]</i>

By	Date	Qty
<i>[Signature]</i>	06-07-25	

[Signature]
06-07-13

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Drawing Name: SPACER KIT

Job Number: 27584

Part Number: D25253

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 547

Rep 1/15 (20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.17

Job Completion



Le 06.07.15

Date: Thursday, 6/15/2006 1:50:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER KIT
Job Number	: 27584		
Estimate Number	: 11800		
P.O. Number	:	Part Number	: D25253
This Issue	: 6/15/2006 S.O. No. :	Drawing Number	: D2525 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: <u> </u>	Due Date	: 6/30/2006
Checked & Approved By	: <u> </u>	Qty:	20 Um: Each
Comment	: Est. B99.14.10 Re-format added Acid etch stepEC		

See
 Replacem
 w/o attached

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O:

Make as per Dwg D2525

Material release note required

Material:
 6061-T6 Ø.750"
 (.022 Feet)

Batch:

2.0 D25253P

Spacer Kit



Comment: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Spacer Kit

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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QC2



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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QC8



Comment: DIMENSIONAL CHECK

5.0	HAND FINISHING 1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:50:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27584

Part Number: D25253

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

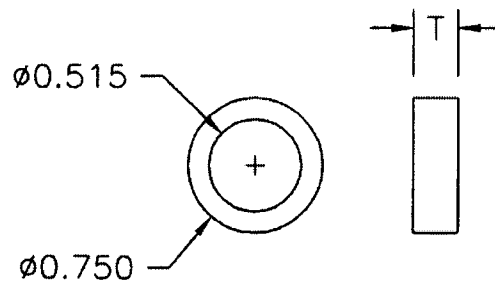
QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED H	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27584

DART AEROSPACE LTD	Work Order:	27584
Description: SPACER	Part Number:	D25253
Inspection Dwg: D2525, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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[illegible]

Measured by:		Audited by:	SD	Prototype Approval:	—
Date:	06/07/11	Date:	06.07.11	Date:	—

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	